

Work Order ID 135823

Thursday, August 20, 2015 2:34:48 PM

135823

Page 1

Item ID: D350-636-047 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Run-on Landing Wearplates Fits LH or RH
 Start Date: 8/20/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/20/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: AUG 20 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
IIN-D350-636	J	JA

MLS 1508-21

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD350-636-047 CHG005								

2 DAS 8 9-89 SEP 18 2015

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

① JA AUG 21 2015 27 9-89

115	QC4- 100% Inspect kits for completeness	0.00							
115									
QC	Memo	0.00							
Quality Control									

2 DAS 8 9-89 SEP 18 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Page 2

Thursday, August 20, 2015 2:34:48 PM

Item ID: D350-636-047

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Run-on Landing Wearplates Fits LH or RH

Start Date: 8/20/2015 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 8/20/2015 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-636-047 Location:FG041								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS
8
9-88

2

SEP 18 2015

MLJ

SEP 18 2015

ME
15-9-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 135823

135823

Parent Item: D350-636-047

D350-636-047

Parent Item Name: Run-on Landing Wearplates Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/20/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 10.09.27 NEW ISSUE DD VERF:EC IPP
Rev:B 11.04.14 ecn11-553 DD verf:EC IPP REV:C AS
PER ECN 11-603 JLM 11.07.07 VERIFIED BY:DD IPP Rev:D 112.04.16
AS PER ECN 12-542 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4154-041		Manufactured	No			110	Each	3.0000		2			
D4154-041									**	JA			
Wearplate Assembly													

DAS
6
9-89

AN3C36A		Purchased	No			110	Each	338.0000		8			
AN3C36A									**	JA			
Bolt													

AUG 21 2015

DAS
6
9-89

Location	Loc Qty	Loc Code
FG	47	
101261	4	
122204	2	
m131367	1	
m132169	40	
FP001	47	
m131856	47	
ST338a	240	
131651	80	
m132381	80	
m132522	80	
ST347	4	
m130874	4	

8

mtf

Picklist Print

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Parent Item: D350-636-047

D350-636-047

Parent Item Name: Run-on Landing Wearplates Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/20/2015

Start Qty: 2.00

Required Qty: 2.00

AN3C37A

Purchased

No

110

Each

499.0000

**

JA

AN3C37A

Bolt

DAS
6
9-89

Location

Loc Qty

Loc Code

ST338a

475

131651

70

M129650

55

M131367

70

M131856

70

M132169

70

M132381

70

M132522

70

ST347

24

129687

24

AN3C42A

Purchased

No

110

Each

68.0000

**

JA

AN3C42A

Bolt

DAS
37
1-89

Location

Loc Qty

Loc Code

FG

5

121103

5

ST338a

20

m132522

10

m132674

10

ST346

11

m132169

1

m132381

10

ST347

32

m130485

2

m131854

10

m131855

10

m131856

10

m132381

AUG 21 2015

27
9-89

Picklist Print

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Work Order ID: 135823

135823

Parent Item: D350-636-047

D350-636-047

Parent Item Name: Run-on Landing Wearplates Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/20/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0363R

Purchased

No

110

Each

369.0000

20

NAS1149C0363R

Washer

**

JA

27

9-89

DAS
8
9-89

Location

Loc Qty

Loc Code

FP001

75

114742

75

GA

97

m130673

97

ST271

197

122441

3

m130673

4

m132763

190

20

MS21043-3

Purchased

No

110

Each

548.0000

10

MS21043-3

Nut

**

JA

AUG 21 2015

27

9-89

DAS
8
9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

11

m130673

11

GA

191

m130673

15

m131677

176

ST304

199

m131340

199

ST308

67

m132551

67

10

Picklist Print

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Work Order ID: 135823

135823

Parent Item: D350-636-047

D350-636-047

Parent Item Name: Run-on Landing Wearplates Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/20/2015

Start Qty: 2.00

Required Qty: 2.00

D3873-1 Manufactured No 110 Each 18.0000

D3873-1
Bushing

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

2

126709

2

ST063

16

134885

16

D4171-1 Manufactured No 110 Each 23.0000

D4171-1
Bushing

DAS
6
9-89

Location

Loc Qty

Loc Code

ST096

23

129060

23

D4170-3 Manufactured No Each 13.0000

D4170-3
Bushing

DAS
6
9-89

Location

Loc Qty

Loc Code

ST096

13

123100

2

131104

1

135749

10

AN3C34A Purchased No 110 Each 8.0000

AN3C34A
BOLT

DAS
6
9-89

Location

Loc Qty

Loc Code

ST348

8

m131618

8

**

JA

B35921x6

27
9-89

**

JA

27
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JA

27
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JA

AUG 21 2015

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9-89

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Shop Packet Print

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8.0 PARTS LIST (D350-636-015/-016/-017/-018/-047 KITS)

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -047	Part Number	Description
	X					D350-636-015	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE W/ TRAINING WEARPLATE
		X				D350-636-016	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE W/ TRAINING WEARPLATE
			X			D350-636-017	SKIDTUBE INSTALLATION, LH AIRCROUSER/ APICAL TRI-BAG FLOAT COMPATIBLE W/ TRAINING WEARPLATE
				X		D350-636-018	SKIDTUBE INSTALLATION, RH AIRCROUSER/ APICAL TRI-BAG FLOAT COMPATIBLE W/ TRAINING WEARPLATE
					X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1					D4168-041	SKIDTUBE ASSEMBLY, LH
1		1				D4168-042	SKIDTUBE ASSEMBLY, RH
1			1			D4168-043	SKIDTUBE ASSEMBLY, LH
1				1		D4168-044	SKIDTUBE ASSEMBLY, RH
*1	1					D4168-1	SKIDTUBE WELDMENT, LH
*1		1				D4168-2	SKIDTUBE WELDMENT, RH
*1			1			D4168-3	SKIDTUBE WELDMENT, LH
*1				1		D4168-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		2311BAG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1		AN960C816L	WASHER (OR NAS1149CO832R)
*7	1	1	1	1		MS21083C8	NUT
*8	1		1			D3488-041	BLADE FITTING, LH
*8		1		1		D3488-042	BLADE FITTING, RH
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2		AN960JD816	WASHER (OR NAS1149CO863J)
12	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4		AN8C44A	BOLT
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4		AN960C10L	WASHER (OR NAS1149CO332R)
*20B	4	4	4	4		NAS1515H3L	WASHER
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY

(CONTINUED ON NEXT PAGE)

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -047	Part Number	Description
***43	2	2	2	2		D3493-1	WASHER
*90	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	AN3C37A	BOLT ²
91C	1	1	1	1	1	AN3C42A	BOLT ³
*92	7	7	7	7	8	AN880C10	WASHER (OR NAS1149CO363R)
92A			1	1	1	AN880C10	WASHER (OR NAS1149CO363R) ⁴
*93	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	8	D3873-1	BUSHING
94A			1	1	1	D3873-1	BUSHING ³
*95	1	1	1	1	1	D4171-1	BUSHING ⁴
96					4	D4170-3	SPACER
*97	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	AN880C10	WASHER (OR NAS1149CO363R)
*99	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH APICAL CYLINDRICAL OR TRI-BAG FLOATS² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH APICAL CYLINDRICAL BAG FLOATS³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH APICAL TRI-BAG FLOATS⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH APICAL TRI-BAG FLOATS